

628-014

Dart Aerospace Ltd.

11

Friday, 1/25/2008 10:49:36 AM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B FLOAT STEP ASSY, RH
 Part Number : 36964A
 Estimate Number : 11663
 P.O. Number :
 This Issue : 1/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2841042
 First Issue : 1/1 Type : LARGE FAB ASSY Drawing Number : D2841 REV B
 Previous Run : 23321A Project Number : N/A
 Material :
 Due Date : 3/10/2008 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : *[Signature]* 080125
 Comment : Est Rev: D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>1336923</i>

Check Material for any Dents or Defects

SAD 08/03/18

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2841-2 using D2622 extrusion as per Dwg D2842

*SAD**08/03/18**(6)*

2-Drill extrusion per drawing D2842 using Jig DT 8265

*SAD 08/03/18**(6)*

3-Deburr and bevel ends for welding

*SAD 08/03/18**(6)*

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>336520</i>

[Signature] 08.03.18 6

4.0 D34641 mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Lug

Pick:

[Signature] 08.03.18 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FLOAT STEP ASSY, RH

Job Number: 36964A

Part Number: D2841042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
1	D3464-1	Plate	825425=3 337791=4

Batch

825425=3 337791=4

08-03-19

6

5.0

D34643

mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-3	Plate	325426=2

Batch

325426=2

08-03-19

6

6.0

D34645

mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-5	Plate	325427

Batch

325427

08-03-19

6

7.0

D34647

mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-7	Plate	325428

Batch

325428

08-03-19

6

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

AFT End only

1-Weld end cap (AFT END ONLY) and lugs as per Dwg D2841

using Jig DT 8267 followed by DT 8268

A/R AL ROD Batch: m106834

m106762

2-Grind end cap welds flush

08-03-25

08-03-25

SAD 08/03/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Friday, 1/25/2008 10:49:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FLOAT STEP ASSY, RH

Job Number: 36964A

Part Number: D2841042

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

~~DO NOT USE~~

QC 9/5

WELD INSPECTION

08/03/27



08/03/27



Comment: WELD INSPECTION

08/03/27

PD

08-03-27

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-03-28

08-03-28

46

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/03/28

46

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remaining end cap as per Dwg D2841

using Jig DT 8267 followed by DT 8268

A/R AL ROD Batch: ~~mid6767~~ mid6834

08-04-01

08-04-01

6

6

PTO

13.0

QC 10

VISUAL WELDING INSPECTION

08/04/01



Comment: VISUAL WELDING INSPECTION

08/04/02

46

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/02

46

15.0

POWDER COATING

POWDER COATING



107550



Comment: POWDER COATING

Touch up Alodine & Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

08-04-02

46

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/04/03

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.04.02	12b.	grind end cap welds flush as per drawing 2841.	<i>[Signature]</i>	08.04.02	6		<i>[Signature]</i> 08/04/02

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Friday, 1/25/2008 10:49:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FLOAT STEP ASSY, RH

Job Number: 36964A

Part Number: D2841042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

NAS1329C3KB130

insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

4

NAS1329C3KB130

Insert

m/106951

FL

18.0

MS27039C107

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4

MS27039C1-07

Screw

m/107008

FL

19.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4

NAS1515H3L

WASHER

m/106516

FL

20.0

AN960C10L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4

AN960C10L

WASHER

m/107008

FL

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: m/107385

FL 08/04/03 (6)

22.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

S 08/04/03 (6) (R)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FLOAT STEP ASSY, RH

Job Number: 36964A

Part Number: D2841042

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 71

Rev F

8/4/7

30

(6X)

24.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-08

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

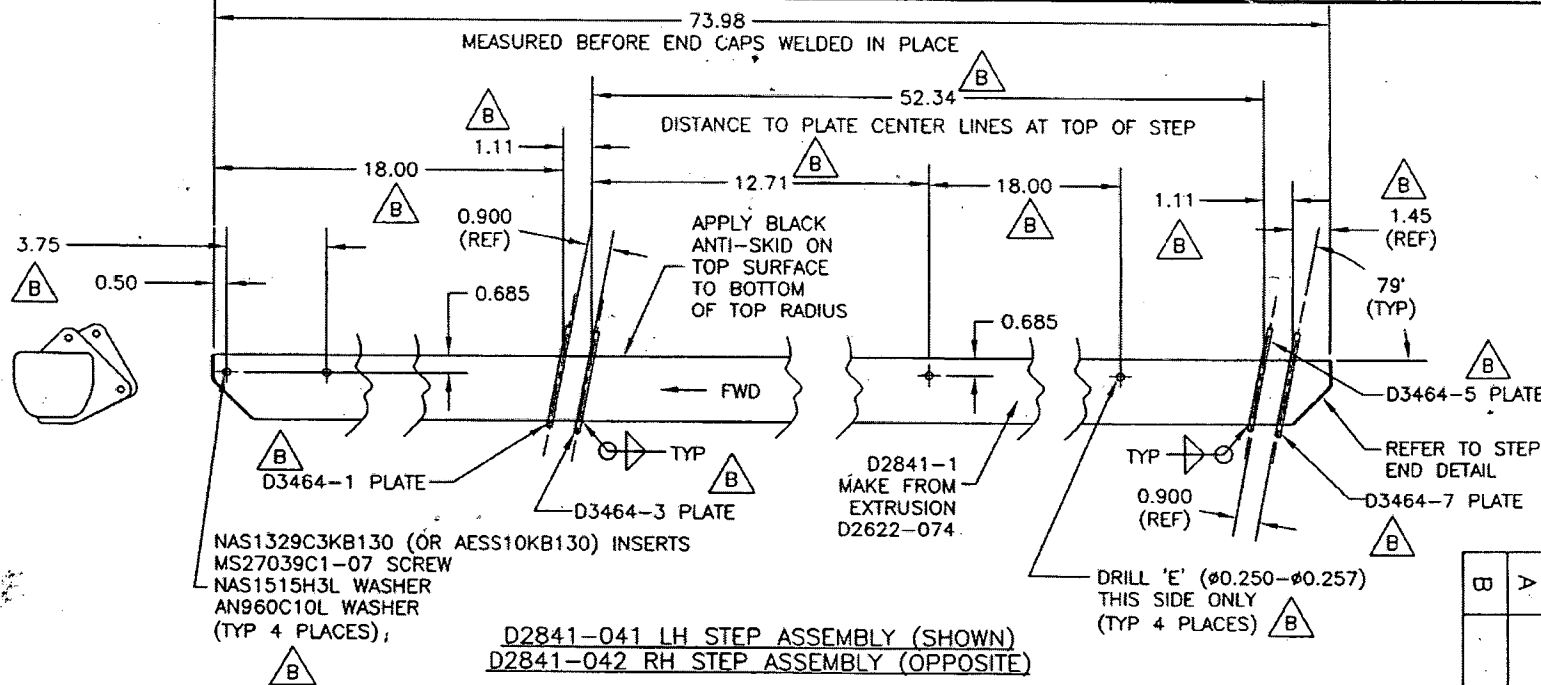
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

DART



D2841-041 LH STEP ASSEMBLY (SHOWN)
D2841-042 RH STEP ASSEMBLY (OPPOSITE)

D2841-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X	X	D2841-041	LH STEP ASSEMBLY
	X	D2841-042	RH STEP ASSEMBLY
1	1	D2622-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	NAS1329C3KB130 (OR AESS10KB130)	INSERT
4	4	MS27039C1-07	SCREW
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER

NOTE: ALL WELDS SHALL
 BE 100% VISUALLY
 INSPECTED BY A QUALIFIED
 INSPECTOR PER DART
 QSI 004

D2841-041/-042 STEP ASSEMBLY

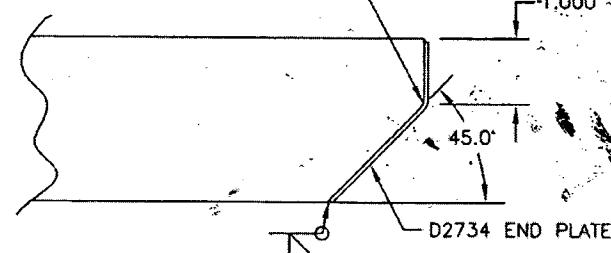
MAKE FROM EXTRUSION D2622
 WELD PER DART QSI 004

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

ALL DIMENSIONS ARE IN INCHES

ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ROUND CORNER OF EXTRUSION TO
 MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

RELEASED
 05-11-14

NO. 369644
 WORK ORDER
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE

DESIGN	KE	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED		APPROVED	PORT HADLOCK, WA
DATE	05.09.21	TITLE	D2841
	A	98.10.14	DRAWING NO.
	B	05.09.21	RE-DESIGN, ADD D2843-1/-3/-5/-7
		NEW ISSUE	
		206B FLOAT STEP ASSEMBLY	
		NTS	
		SHEET 1 OF 1	
		SCALE	
		REV. B	